

Work Order ID 69911

Tuesday, May 24, 2011 1:01:03 PM



Page 1

Item ID: D2724-042

Accept



Setup Start



Revision ID:

Stop



Item Name: 206L Step Assembly

Start Date: 5/24/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: *NP*Date: *11-05-24*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2724

Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Cut D2724-2 using D2622 extrusion as per Dwg D2724
Deburr and bevel ends for welding*11.06.03 2 0*

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld end cap (One End Only) and lugs as per Dwg D2724 using Jig DT8898
followed by Jig

A/R AL ROD Batch:

M114703
M115928

Grind end cap welds flush

11.06.03 2 0

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2724-042

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

2 0 DEN/06/07

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S u 106/07

72
RH

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

H/A.C. 11.06.08

2 0

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			






NOTE: Date & initial all entries

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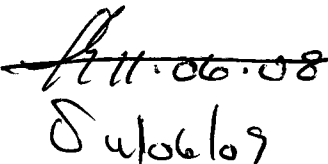


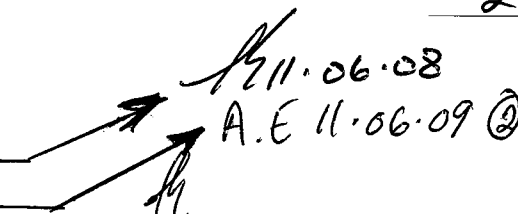


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Item ID: D2724-042 Accept  Setup Start 
Revision ID: Stop 
Item Name: 206L Step Assembly
Start Date: 5/24/2011 Start Qty: 2.00  Cust Item ID:
Required Date: 5/31/2011 Req'd Qty: 2.00  Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	 11.06.08 Suloblor			2	0		
160  Large Fab Large Fab	Large Fab Memo Inspect for foreign object per QSI 024 Weld Remainig end cap as per Dwg D2724 A/R AL ROD Batch: <u>1114703</u> <u>Grind end plate flush.</u>	0.00 0.00				2	0		
170  QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00	 11.06.08 A.E 11.06.09 Suloblor			2	27		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial * Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Item ID:	D2724-042	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	206L Step Assembly					
Start Date:	5/24/2011	Start Qty:	2.00		Cust Item ID:	
Required Date:	5/31/2011	Req'd Qty:	2.00		Customer:	

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		<i>Suloblor</i>		<i>x2</i> <i>RH</i>			
190 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							<i>2x</i> <i>Ø</i> <i>M/L 11/06/09</i>
200 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: <i>10:20</i> OVEN TEMPERATURE: <i>320 °F</i> FINISH TIME: <i>10:50</i>	0.00 0.00							<i>2x</i> <i>Ø</i> <i>M/L 11/06/10</i> <i>RH</i>

NA116964

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



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Item ID: D2724-042 Accept  Setup Start 
Revision ID:
Item Name: 206L Step Assembly Stop 
Start Date: 5/24/2011 Start Qty: 2.00  Cust Item ID:
Required Date: 5/31/2011 Req'd Qty: 2.00  Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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210	QC3- Inspect Part Finish	0.00							
-----	--------------------------	------	--	--	--	--	--	--	--



QC	Memo	0.00							
----	------	------	--	--	--	--	--	--	--

Quality Control

2 BR 11-6-13.

220	Wing Walk as per dwg QSI005 4.4 Batch <u>117863</u>	0.00							
-----	---	------	--	--	--	--	--	--	--



HandFinish	Memo	0.00							
------------	------	------	--	--	--	--	--	--	--

Hand Finishing

2 RH BR 11-6-13.

230	QC3- Inspect Part Finish	0.00							
-----	--------------------------	------	--	--	--	--	--	--	--



QC	Memo	0.00							
----	------	------	--	--	--	--	--	--	--

Quality Control

2 RH f Illaloe 13

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
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Item ID: D2724-042

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Item Name: 206L Step Assembly

Start Date: 5/24/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

250

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

JSP 69909

11/6/14

11/6/14
ME
11-06-14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1
2

Work Order ID: 69911



Parent Item: D2724-042



Parent Item Name: 206L Step Assembly

Start Date: 5/24/2011


Required Date: 5/31/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:E As Per Ecn 766 06-01-06 JLM


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2734  Step End Plate		Manufactured	No			110	Each	68.0000	1	2			
--	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location Loc Qty Loc Code

WA 45
69537 45
WA015 23
66143 23


2
11.06.03

D3458-1  Step Mounting Plate		Manufactured	No			110	Each	31.0000	2	4			
---	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location Loc Qty Loc Code

WA018 31
63075 31

2
11.06.03

D3458-3  Step Mounting Plate		Manufactured	No			110	Each	38.0000	2	4			
---	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location Loc Qty Loc Code

WA018 38
63076 38

4
11.06.03

4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 69911



Parent Item: D2724-042



Parent Item Name: 206L Step Assembly

Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 2.00

Required Qty: 2.00

D2734

Manufactured No

160

Each

68.0000

1

2



Step End Plate



11-06-08

Location

Loc Qty

Loc Code

WA

45

69537

45

WA015

23

66143

23

D2622-120C

Manufactured No

100

Each

64.0000

1

2



Step Extrusion



11-06-03

Location

Loc Qty

Loc Code

HALL

6

64409

6

WA

58

46910

2

66970

56

2

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
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